

Date: Wednesday, 18/06/2008 1:26:39 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MIRROR BRACKET		
Job Number	: 39920			Part Number	: D2010101		
Estimate Number	: 10245			Drawing Number	: D2010 PRELIM		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/06/2008	S.O. No.	:	Drawing Revision	: PRELIM		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 30/06/2008		
Previous Run	: 39505			Qty:	20	Um:	Each
Written By	:			Comment	:		
Checked & Approved By	: JUO 08.06.18			Est:E 02.06.25	Added Rev. C1 KJ/RF		
				Est Rev:F 07-08-015	Now on WaterJet Verified By:EC		
				Est Rev:G 08-05-27	as per ECN1195P DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.3646 sf(s)/Unit Total : 7.2912 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	108415 Batch: 107276 HB 8-7-3
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2010-101 Dwg Rev: <u>D</u> Prog Rev: <u>D</u>	HB 8-7-3
		2-Deburr if necessary	HB 8-7-3
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	HB 8-7-3
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>S 08/07/03 ✓26 counter</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>w/a Done at step #22 8/08/03</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



(P2) →

Comment: NC BRAKE

Form as per Dwg D2010

S0 08/07/07

5 20 FE032EF Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Inserts

Pick:

Qty	Part Number	Description	Batch
4	FE-032-EF	Insert	M10 7896 6X M10 8313 78

5 10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install fasteners per Dwg D2010

QC5 INSPECT WORK TO CURRENT STEP

5 12.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

S0 08/07/07 (21) counter

5 10.0 POWDER COATING POWDER COATING



m102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

(21)

START TIME: 11.30
OVEN TEMPERATURE: 320
FINISH TIME: 12.00

QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION

S0 08/07/09 (21) counter

5 9.0 QC3



Comment: INSPECT POWDER COAT

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 228

88 08/07/11 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/08	6.1	Inspect DC #5	S	08-07-07 (2)	Q	08-07-08	08-07-08
	7.0	Chemical coat as per QSZ005	JK/BK	08-07-08 (2)	E		08-07-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

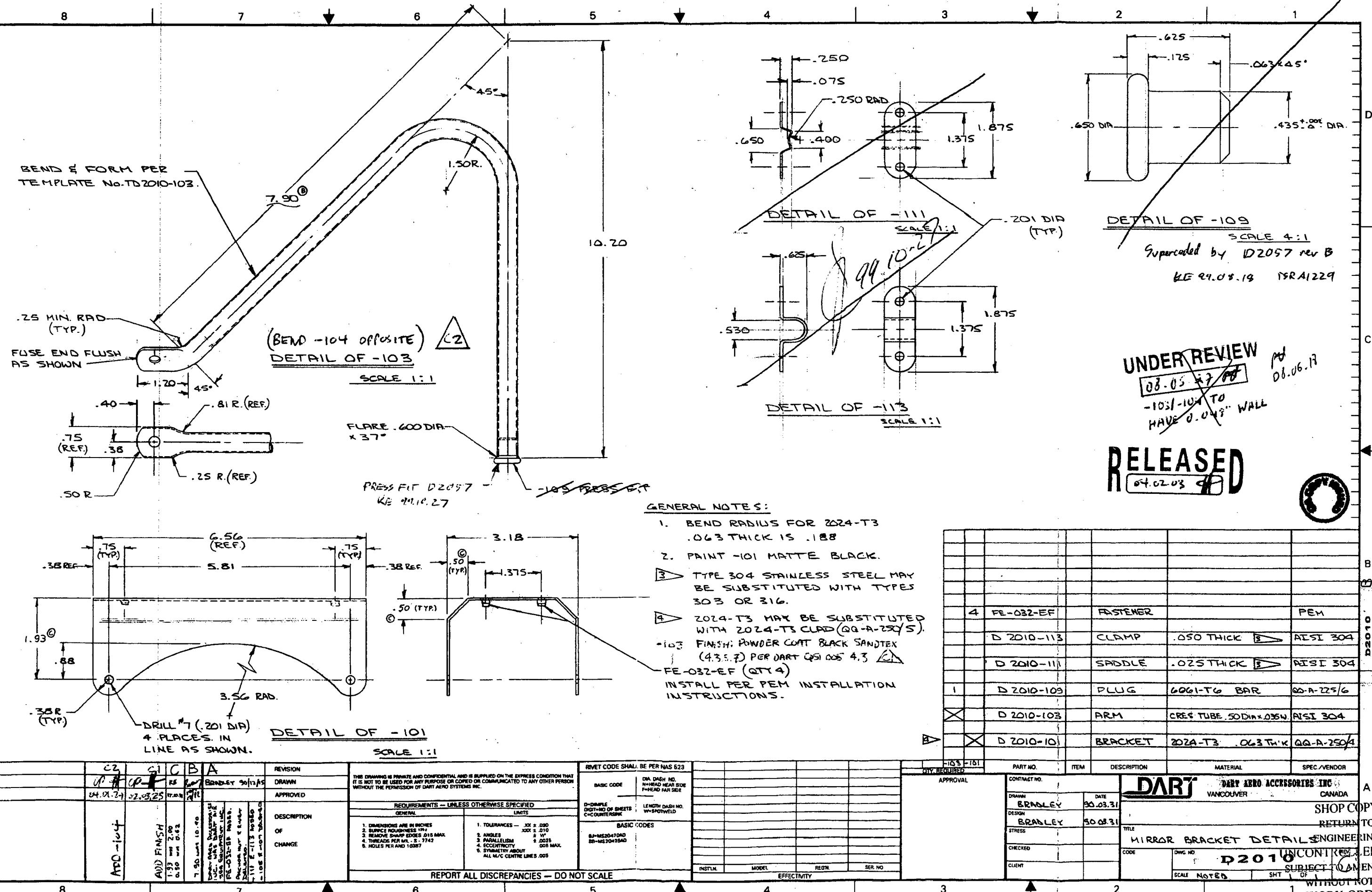
DART AEROSPACE LTD	Work Order:	39920
Description: Bracket	Part Number:	D2010-101
Inspection Dwg: D2010	Rev: C2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article  Prototype

Measured by:	13	Audited by:	8	Prototype Approval:	N/A
Date:	8-7-3	Date:	08/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.06	New Issue	KJ/RF	
B	06.03.08	Dwg rev. changed	KJ/JLM	<i>[Signature]</i>



NO. 399-100

